



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D5483-041
Job Sheet 195821



Part No: D5483-041

Job Qty: 20 pcs

Part Name: Tow Cap Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/30/19

Job Tracking No:

Due Date: 7/2/19

Created By: Kimberley Guerin

Type: Stock *SAD*

Description:

Note: D5483 REV:B IPP REV:A 17.05.26 NEW ISSUE DD VERF:JFS IPP REV:B 17.11.03 AS PER DWG REV:A DD
VERF:DP IPP REV:C AS PER DWG REV.B JFS 18.10.05 VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	20 pcs		7/2/19	0.00	2.00	Bandsaw - 1		<i>mk 19/07/20</i>
110	HAAS 5 Axis - B4B	20 pcs		7/2/19	0.00	13.28	HAAS - 5 - B4B		<i>mk 19/07/21</i>
115	QC 2	20 pcs		7/2/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		<i>mk 19/07/22</i>
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		



Container No: S199399



Part: D5483 - 041

Job No: 195821

Serial No/Batch: S199399

Revision: B

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
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CANADA
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Email: sales@dartaero.com
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Date: 07/22/19

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120 QC 8	20 pcs	7/2/19	0.00 0.00	QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	19-07-23
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
130 Handfinish - 1-1 Chemical-B4B	20 pcs	7/2/19	0.00 1.33	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	JUL 23 2019
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	

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					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
135 QC 7	20 pcs	7/2/19	0.00	0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
140 Small Fab - 2 - B4B	20 pcs	7/2/19	0.00	5.00	Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
150 QC 5	20 pcs	7/2/19	0.00	0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	

DAS 30 9-33 JUL 2 2019

JUL 23 2019

**DAS
15
9-89**

				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	20 pcs	7/2/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	JUL 26 2019
				QC 21 - SA - 53	

Part Op 100 - CUT BLANK AT 4.200"

Descriptions: 110 - (HAAS CNC vertical machine #5), 1-Machine per folio FC024. DWG REV: B FOLIO REV: AA 2-

Deburr and break all sharp edges. 3- Check hole alignment as per note8

115 - (QC2- Inspect parts off machine FAI/FAIB)

120 - (QC8- Inspect parts - second check)

130 - (Chemical Conversion Coat per QSI005 4.1)

135 - (QC7-Inspect Chemical Conversion Coat)

140 - Install nut plates as per dwg

150 - (QC5- Inspect part completeness to step on W/O)

160 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum), ***HAND TIGHT A SCREW IN THE NUTPLATE PRIOR TO POWDERCOAT*** START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____

170 - (QC3- Inspect Part Finish)

180 - (Identify as per dwg & Stock Location: _____)

190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R3.750	6061-T6 Round Bar 3.750"	7 ft (.35 ea)	100-Bandsaw - 1	14x 5070816
CCR264SS-3-03	Cherry Rivet	160 Ea (8 ea)	140-Small Fab - 2 - B4B	6x 519526
MS21075L3N	Nut Plate	80 Ea (4 ea)	140-Small Fab - 2 - B4B	8x 174225

S 194456

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6R3.750	7	5	0
140-Small Fab - 2 - B4B	CCR264SS-3-03	160	238	0
	MS21075L3N	80	124	0

Part Specifications

Specifications could not be found.

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INSPECTION SHEET

DAS
20

Engineering Approval:
(If necessary)

H:\FORMS\Quality Assurance\approved QA\Inspection Sheet revB